

Date: Monday, 3/19/2007 4:39:24 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|---------------------|
| *Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FWD TUBE ASSEMBLY |
| Job Number | : 31305 | | |
| Estimate Number | : 10467 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D3391021 |
| This Issue | : 3/19/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3391 REV.F |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : MACHINED PARTS | Drawing Revision | : F |
| Previous Run | : 30926 | Material | : <i>N/A</i> |
| Written By | : | Due Date | : 4/10/2007 |
| Checked & Approved By | : <i>JA 07.03.20</i> | Qty: | 1 Um: Each |
| Comment | : Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC Est. C 06.05.02 Added inspections EC est D 07.03.13 rev F dwg EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|----------------|
| 1.0 | D6013047 | SKIDTUBE MAT'L |
|-----|----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SKIDTUBE MAT'L

Pick:

| | | |
|-----|-------------|-------------|
| Qty | Part Number | Description |
| 1 | D6013-047 | Extrusion |

Batch: *B 26 547*

JB 7-3-22

| | | |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1
Cut extrusion to 46.52 +0.010 -0.020

JB 7-3-22

| | | |
|-----|---------|-----------------|
| 3.0 | BENDING | BENDING MACHINE |
|-----|---------|-----------------|



Comment: No bender
Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-3-28

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

DP 7-3-29

| | | |
|-----|-------|--------------------------------|
| 5.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *F*
Identify as D3391-1

2-Deburr

BC 07.04.01 ① RTO

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3321-021 PAR #: N/A Fault Category: Prod/Machined Parts NCR: ☒ Yes ☐ No DQA: 2 Date: 07/07/23
 QA: N/C Closed: 9 Date: 07.07.23

| NCR: <u>31305</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|-----------------------------|--|---|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07.04.01 | 5 | Machined section is not parallel to tube after bend. | <u>AB</u> 07/07/16 | Inconnect set up. Mistake corrected. Scrap./destroy | <u>36</u> 07.04.01 <u>AB</u> 07-16 | <u>36</u> 07/07/23 | <u>AB</u> 07/07/16 | <u>AB</u> 07-02 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Drawing Name: FWD TUBE ASSEMBLY

Part Number: D3391021

[illegible]

Description :

INSPECT PARTS AS THEY COME OFF MACHINE

[REDACTED]

[illegible]

36 07.05.01

SECOND CHECK

[illegible][illegible]

~~0/17 0/16 0~~

LANDING GEAR RESOURCE 1



6--Deburr

INSPECT WORK TO CURRENT STEP

[illegible]

[REDACTED]

Comment: INSPECT WORK TO CURRENT STEP

HAND FINISHING RESOURCE #1

[illegible][illegible]

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

INSPECT POWDER COAT/CHEMICAL CONVERSION

1. The first group of respondents was the group of respondents who were not in the sample. This group was used to estimate the probability of being in the sample. The probability of being in the sample was estimated by dividing the number of respondents in the sample by the number of respondents in the population. The probability of being in the sample was estimated to be 0.15.

[illegible]

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

POWDER COATING

... ..

[illegible]

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Page 2

Form:

Dart Aerospace Ltd
W/O:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:39:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31305

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivnut

Pick:

| Qty | Part Number | Description | Batch |
|-----|----------------|-------------|-------|
| 14 | NAS1330C3KB166 | Insert | |

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D3401-041 | Tow Cap | |

18.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

19.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:39:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31305

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 4 | AN3C4A | Bolt | |

21.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 4 | NAS1515H3L | Washer | |

22.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U. Skofic

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

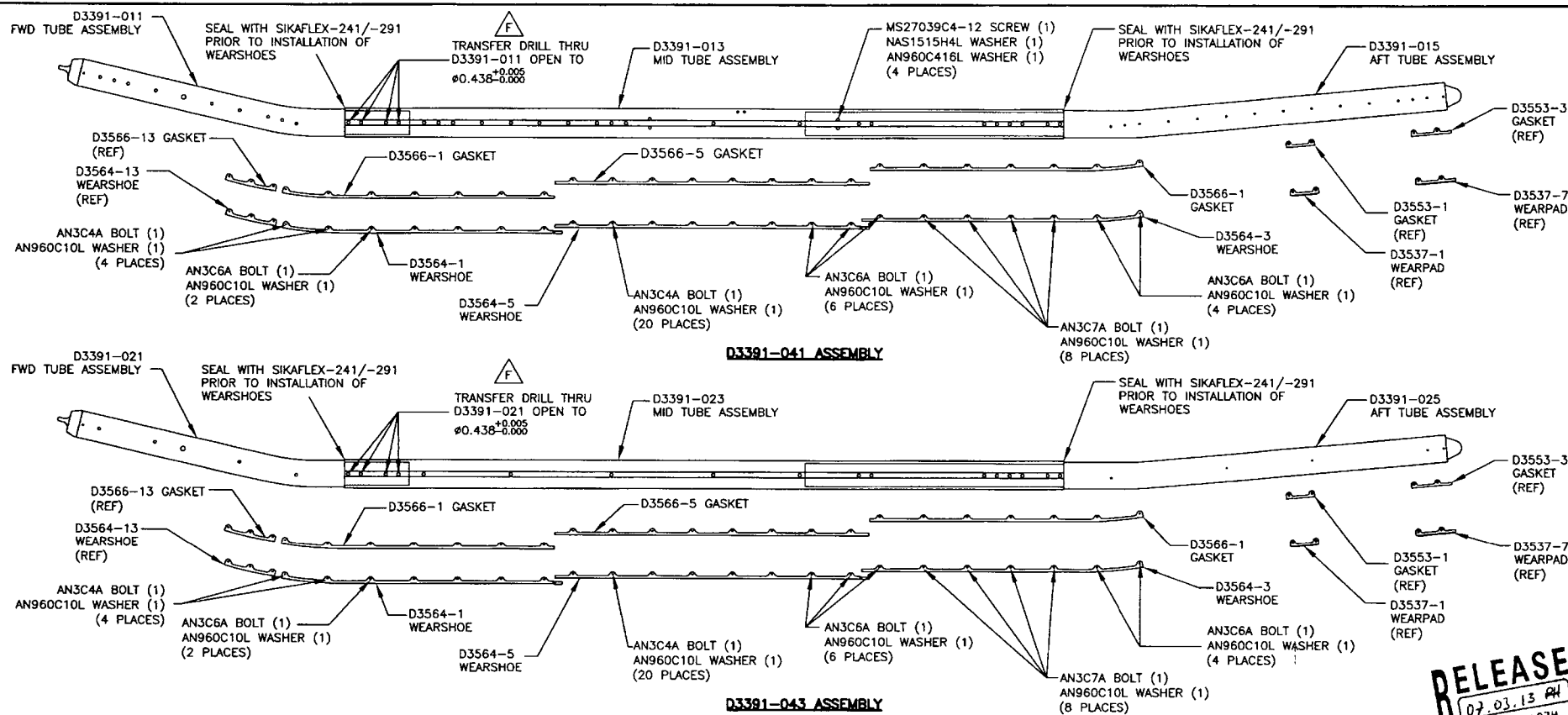
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
07.01.13 RH
per E.N. #934

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|----------|----------|--------------|-------------------------|
| X | X | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| | | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | | D3391-013 | MID TUBE ASSEMBLY |
| 1 | | D3391-015 | AFT TUBE ASSEMBLY |
| 1 | 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D3564-1 | WEARSHOE |
| 1 | 1 | D3564-3 | WEARSHOE |
| 1 | 1 | D3564-5 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 24 | 24 | AN3C4A | BOLT |
| 12 | 12 | AN3C6A | BOLT |
| 8 | 8 | AN3C7A | BOLT |
| 44 | 44 | AN960C10L | WASHER |
| 4 | | MS27039C4-12 | SCREW |
| 4 | | NAS1515H4L | WASHER |
| 4 | | AN960C416L | WASHER |

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391/Ø0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

NO. 31305
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

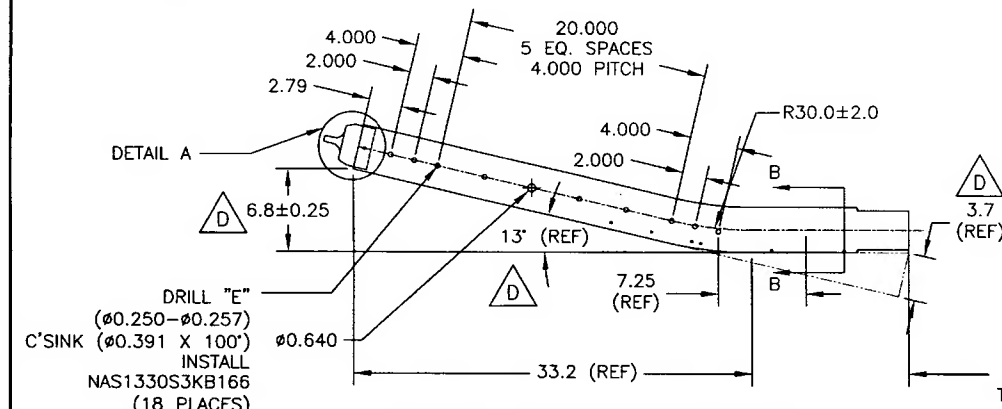
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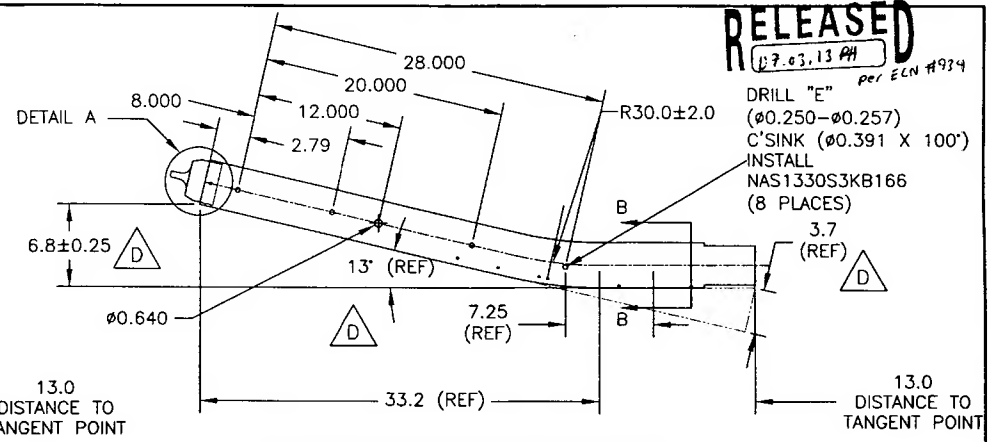
| | | |
|---------|----------|---|
| F | 07.01.18 | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021 |
| E | 06.04.25 | CHANGE TOLERANCE, EASE MANUFACTURE |
| D | 06.01.23 | UPDATE TOLERANCE, CHANGE HOLE SIZE |
| C | 05.09.27 | LENGTHEN AFT EXTENSION |
| B | 05.06.10 | DRAWING UPDATES |
| A | 05.02.07 | NEW ISSUE |
| DESIGN | PH | DRAWN BY |
| CHECKED | PH | APPROVED |
| DATE | 07.01.18 | TITLE |
| | | 412 FLOAT SKIDTUBE |
| | | REV. F |
| | | SHEET 1 OF 5 |
| | | SCALE |
| | | NTS |

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

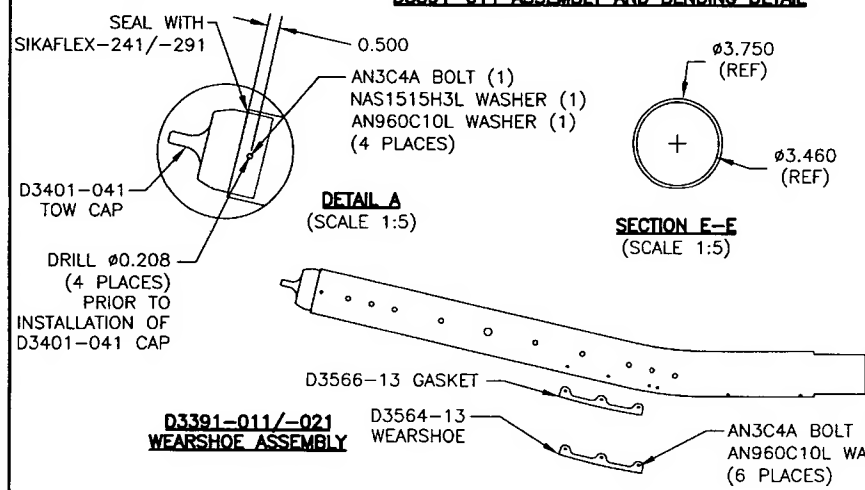
RELEASED
 07.03.13 AH
 Per ELN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL



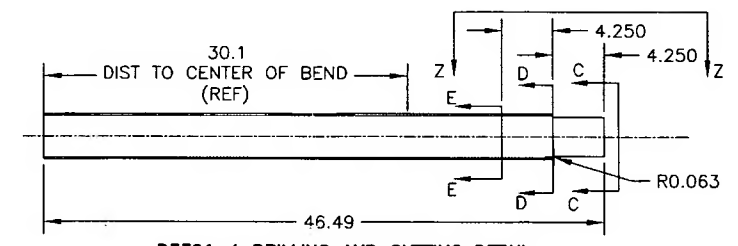
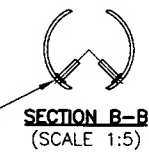
D3391-011/-021 WEARSHOE ASSEMBLY

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY - 011 | QTY - 021 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | | D3391-011 | FWD TUBE ASSEMBLY |
| | X | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D6013-047 | FWD TUBE |
| 1 | 1 | D3401-041 | TOW CAP |
| 1 | 1 | D3564-13 | WEARSHOE |
| 1 | 1 | D3566-13 | GASKET |
| 10 | 10 | AN3C4A | BOLT |
| 4 | 4 | NAS1515H3L | WASHER |
| 10 | 10 | AN960C10L | WASHER |
| 30 | 20 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |

UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY
 5
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

DRILL "E"
 (0.250-0.257)
 C'SINK (0.391 X 100")
 INSTALL
 NAS1330S3KB166
 (12 PLACES)

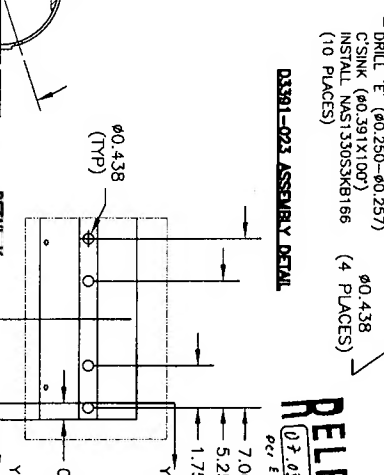
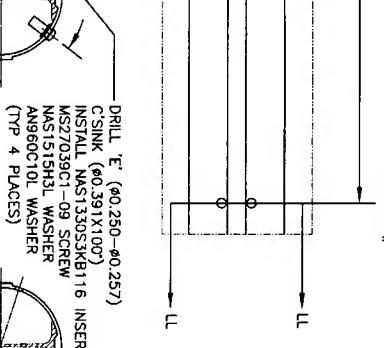
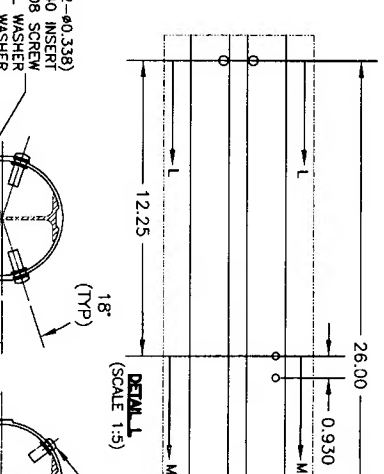
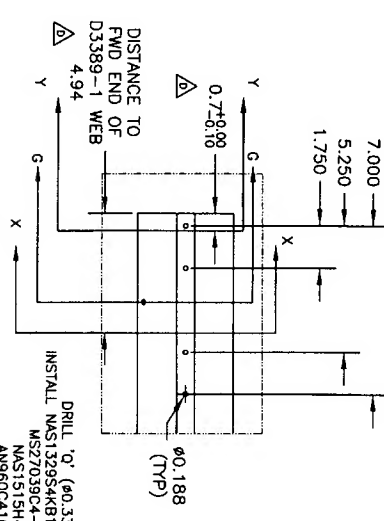
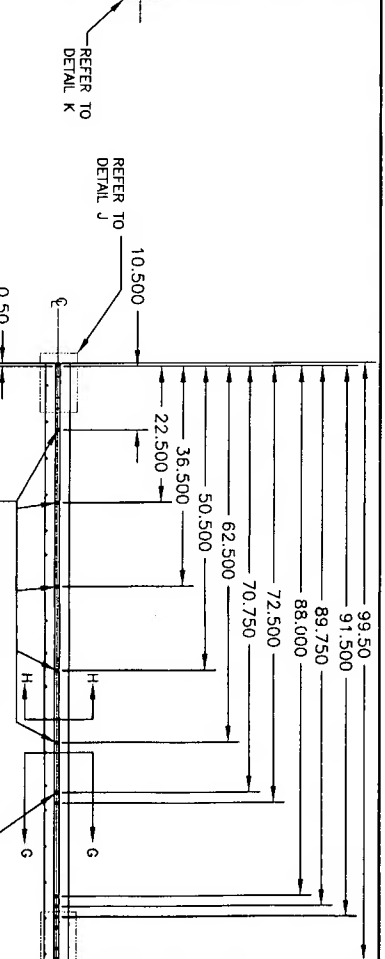
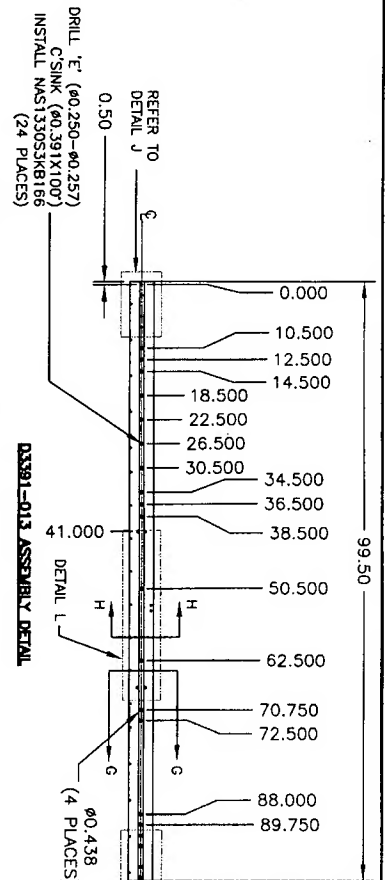


D3391-1 DRILLING AND CUTTING DETAIL
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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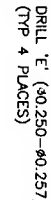
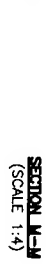
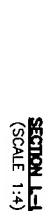
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| DESIGN | DRAWN BY | DART | DART AEROSPACE USA, INC. |
|----------|----------|--------------------|--------------------------|
| PH | PH | | |
| CHECKED | APPROVED | DRAWING NO. | REV. F |
| | | D3391 | SHEET 2 OF 5 |
| DATE | | TITLE | SCALE |
| 07.01.18 | | 412 FLOAT SKIDTUBE | 1:10 |



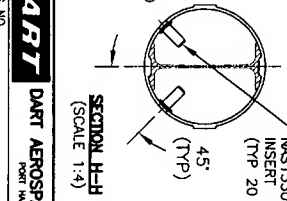
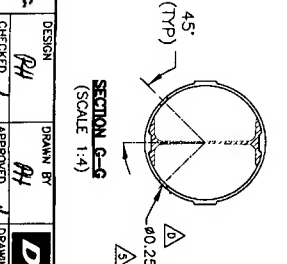
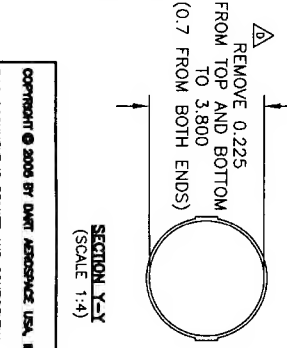
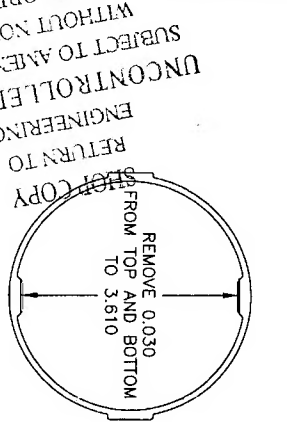
D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - | QTY - | PART NUMBER | DESCRIPTION |
|-------|-------|----------------|----------------------------|
| 013 | 023 | | |
| X | | D3391-013 | MID TUBE ASSEMBLY |
| X | | D3391-023 | MID TUBE ASSEMBLY |
| 1 | 1 | D2500-1-100 | EXTRUSION |
| 1 | 1 | D3389-1 | WEB |
| 24 | 20 | NAS1330S3K8116 | INSERT (OR NAS1330S3K8116) |
| 24 | 10 | NAS1330S3K8116 | INSERT (OR NAS1330S3K8116) |
| 4 | 4 | NAS1329S4K8140 | INSERT (OR NAS1329S4K8140) |
| 4 | 4 | NAS1515H3L | WASHER |
| 4 | 4 | AN960C10L | WASHER |
| 4 | 4 | AN960C416L | WASHER |
| 4 | 4 | MS27039C1-09 | SCREW |
| 4 | 4 | MS27039C4-08 | SCREW |



D3391-013/-023 MID TUBE ASSEMBLY

| QTY - | QTY - | PART NUMBER | DESCRIPTION |
|-------|-------|----------------|----------------------------|
| 013 | 023 | | |
| X | | D3391-013 | MID TUBE ASSEMBLY |
| X | | D3391-023 | MID TUBE ASSEMBLY |
| 1 | 1 | D2500-1-100 | EXTRUSION |
| 1 | 1 | D3389-1 | WEB |
| 24 | 20 | NAS1330S3K8116 | INSERT (OR NAS1330S3K8116) |
| 24 | 10 | NAS1330S3K8116 | INSERT (OR NAS1330S3K8116) |
| 4 | 4 | NAS1329S4K8140 | INSERT (OR NAS1329S4K8140) |
| 4 | 4 | NAS1515H3L | WASHER |
| 4 | 4 | AN960C10L | WASHER |
| 4 | 4 | AN960C416L | WASHER |
| 4 | 4 | MS27039C1-09 | SCREW |
| 4 | 4 | MS27039C4-08 | SCREW |



1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER OSI 015

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
RETURN TO
ENGINEERING
WITHOUT NOTICE
31305
WORK ORDER

REMOVE 0.030
FROM TOP AND BOTTOM
TO 3.610

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

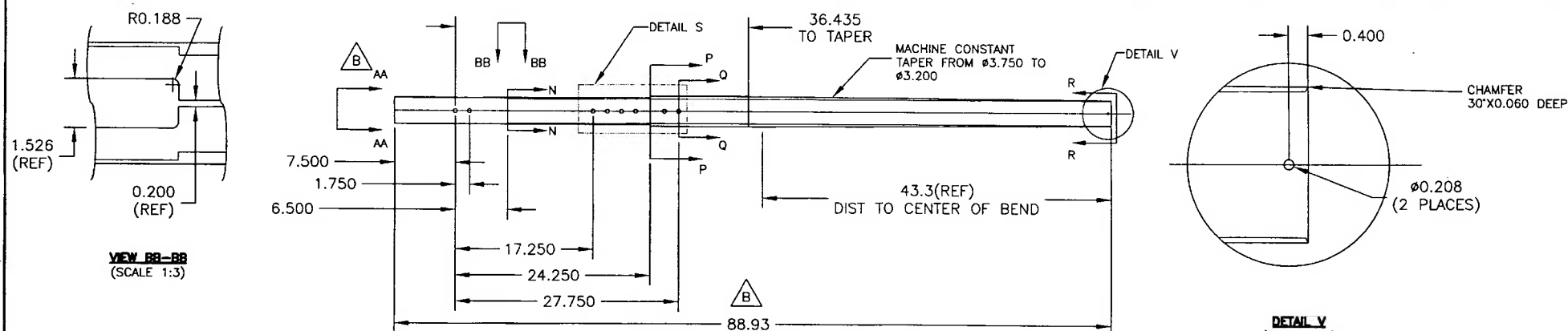
REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

DESIGN: PH
CHECKED: PH
APPROVED: PH
DATE: 07.01.18
TITLE: 412 FLOAT SKIDTUBE
SCALE: 1/20

REVISIONS:
REV. F
SHEET 3 OF 5

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07.01.18
07.01.18

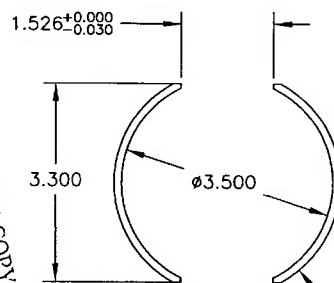


VIEW BB-BB
(SCALE 1:3)

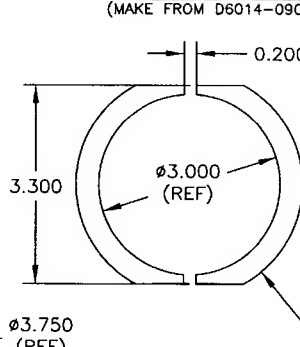
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

DETAIL V
(SCALE 1:2)

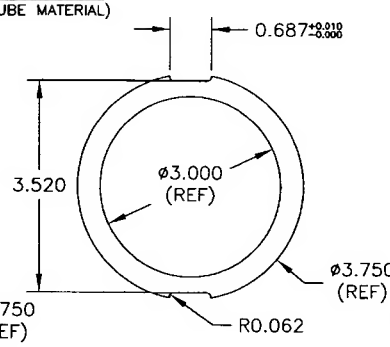
NO. 31305
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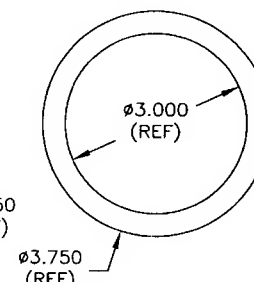
SECTION AA-AA
(SCALE 1:2)



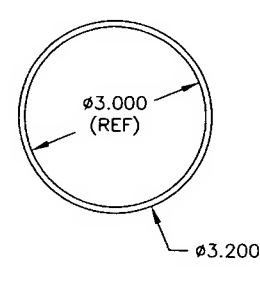
SECTION N-N
(SCALE 1:2)



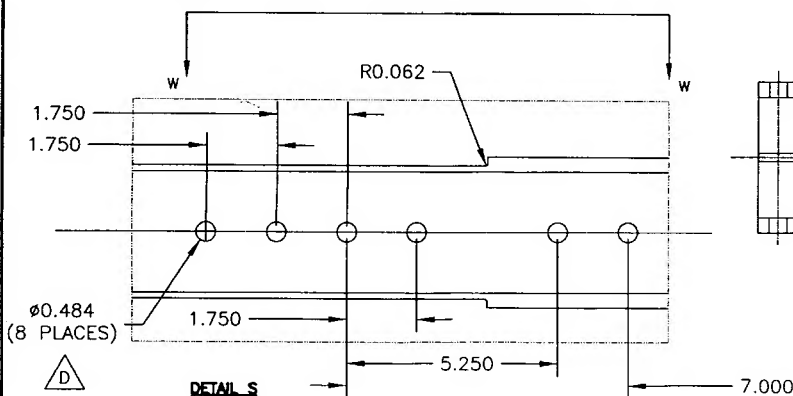
SECTION P-P
(SCALE 1:2)



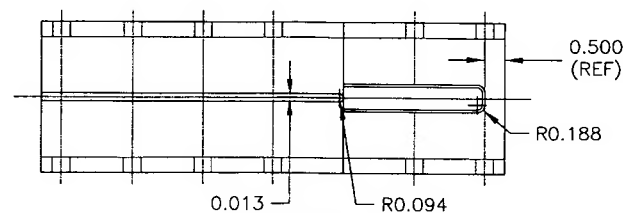
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



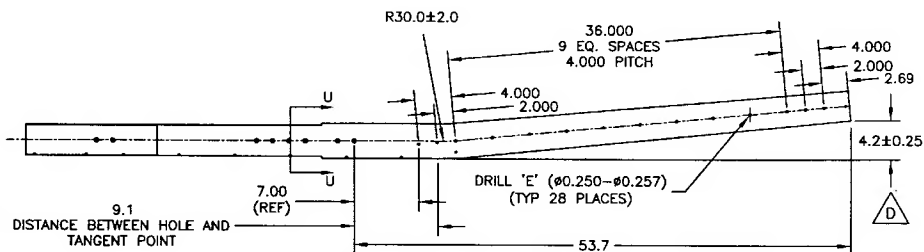
VIEW W-W
(SCALE 1:3)

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 per ESN #934

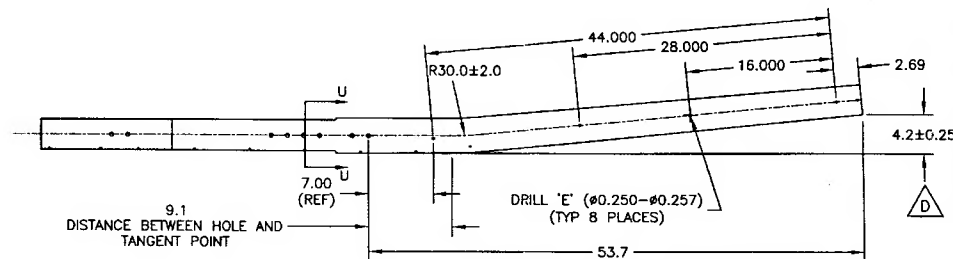
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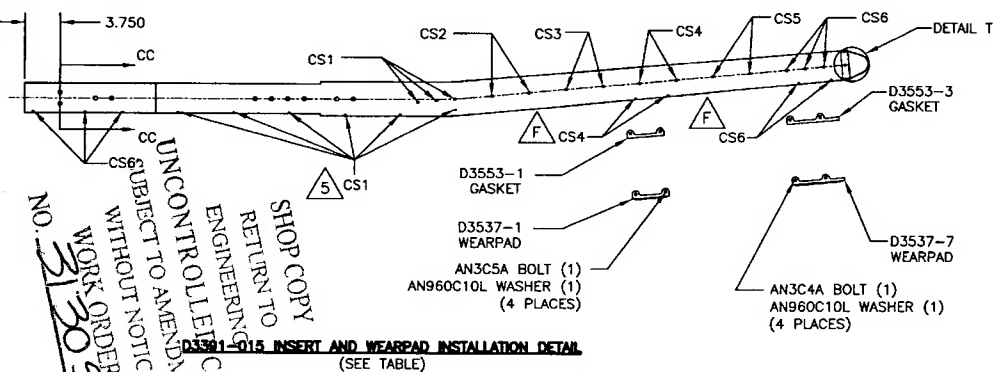
| | | | |
|------------------|-----------------------------|--|--------------|
| DESIGN PH | DRAWN BY PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA | REV. F |
| CHECKED A | APPROVED H | DRAWING NO. D3391 | SHEET 4 OF 5 |
| DATE 07.01.18 | TITLE 412 FLOAT SKIDTUBE | SCALE 1:12 | |



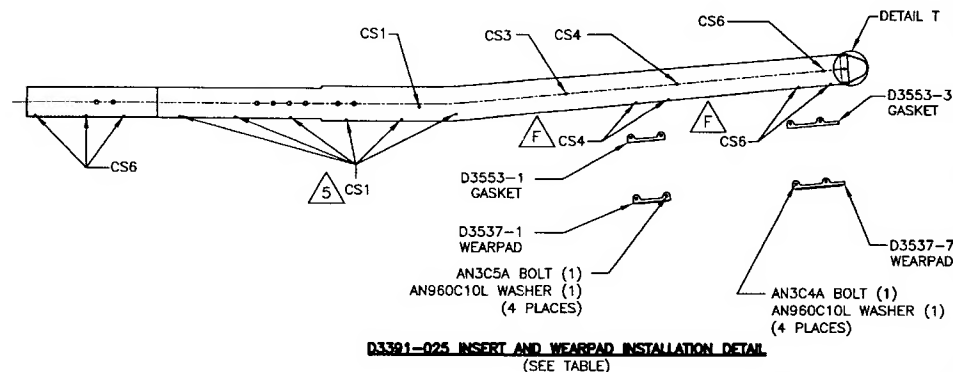
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



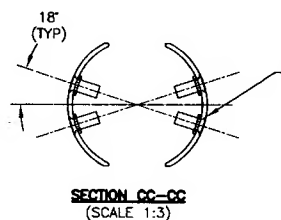
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



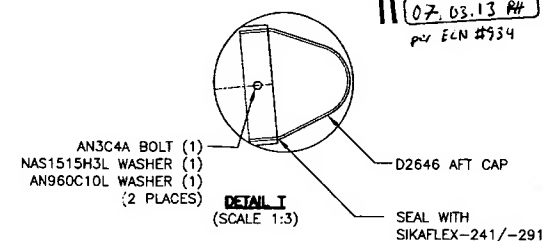
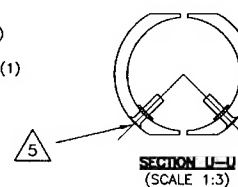
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | X | D3391-015 | AFT TUBE ASSEMBLY |
| | | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D6014-090 | AFT TUBE |
| 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-7 | WEARPAD |
| 1 | 1 | D3553-1 | GASKET |
| 1 | 1 | D3553-3 | GASKET |
| 18 | 14 | NAS1330S3KB366 | INSERT (OR AES10KB366) |
| 4 | 2 | NAS1330S3KB316 | INSERT (OR NAS1330C3KB316) |
| 8 | 6 | NAS1330S3KB266 | INSERT (OR NAS1330C3KB266) |
| 4 | 4 | NAS1330S3KB216 | INSERT (OR NAS1330C3KB216) |
| 16 | 12 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4 | 4 | NAS1330S4KB151 | INSERT (OR NAS1330C4KB151) |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 2 | 2 | NAS1515H3L | WASHER |
| 10 | 10 | AN960C10L | WASHER |



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N |
|--------------|---------------|---------------|--------|----------------|
| CS1 | 18 | 14 | Ø0.425 | NAS1330S3KB366 |
| CS2 | 4 | 2 | Ø0.391 | NAS1330S3KB366 |
| CS3 | 4 | 2 | Ø0.391 | NAS1330S3KB316 |
| CS4 | 8 | 6 | Ø0.391 | NAS1330S3KB266 |
| CS5 | 4 | 2 | Ø0.391 | NAS1330S3KB216 |
| CS6 | 16 | 12 | Ø0.391 | NAS1330S3KB166 |

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| | | |
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| DESIGN PH | DRAWN BY RL | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED H | APPROVED H | DRAWING NO. D3391 |
| DATE 07.01.18 | TITLE 412 FLOAT SKIDTUBE | REV. F SHEET 5 OF 5 SCALE 1:12 |

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